

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019635**Date Inspected:** 14-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

NDT

BAY 14

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted notification number 08165.

Magnetic Particle Testing (MT).

This QA inspector performed MT of approximately 15 % of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

BP3037-001-025~036.

BP3043-001-001~012.

BP3045-001-001~012.

WELDING

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This QA Inspector observed the following work in progress:

### BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 045204 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13CW. Weld joint is identified as SEG3015U-005. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and Critical welding repair report B-CWR2626. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 037840 perform welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13BW. Weld joint is identified as SEG3014L-160, 164. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 201583 perform welding by Flux Cored Arc Welding (FCAW), on OBG Segment 13BW. Weld joint is identified as SEG3014D-183, 184. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 067993 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13BW. Weld joint is identified as SEG3014C-106. ZPMC Quality Control (QC) Inspector identified as Sun Tian Liang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR19997. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 066781 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013V-167. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20129.

This QA Inspector observed ZPMC qualified welding personnel identified as 066481 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013V-309. ZPMC Quality Control (QC) Inspector identified as Liu Fang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20129.

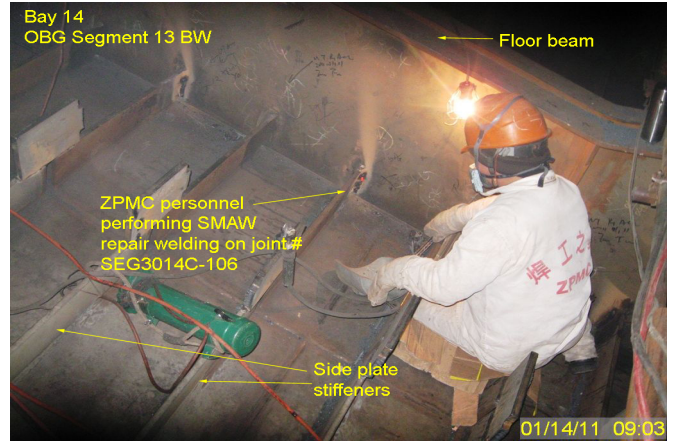
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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**Inspected By:** Upadhye, Anand

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer